



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D3913-041
Job Sheet 199697



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/13/19

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Basket - 1	1 pcs		9/13/19	0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5	SEP 24 2019	DAS 24 9-89
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs		9/13/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS 43 9-89
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs		9/13/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS 43 9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S217051



Part: D3913-041

Job No: 199697

Serial No/Batch: S217051

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/26/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	9/13/19	0.00 0.29		Handfinish - 2 - 1 - B4B	BEB 19-06-27
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White G(S)-B4B	1 pcs	9/13/19	0.00 0.93		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BR 19-07-07
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	9/13/19	0.00 0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-09-30
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	9/13/19	0.00 0.50		Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB 19-09-30
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	9/13/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	26
					QC 21 - SA - 53	21

SEP 3 0 019

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 130/5 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S200407
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S209186
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S209250
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S210814
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S210802
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S214262
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S211960
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S213354
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S212014
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S210909
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S212873
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S210384
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S213780
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S213915
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S210714
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S206462
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S216929
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S202554
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S204283-2
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S216748
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S188988
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136368

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M.U. 012154

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3913-1	1	11	0
	D3913-15	1	17	0
	D3913-3	1	15	0
	D3913-7	2	12	0
	D3913-9	1	6	0
	D3916-041	2	2	0
	D3916-5	3	19	0
	D4016-1	3	19	0
	D4017-7	3	31	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	19	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	1	0
	M304EX0.75-16F	32	1,051	0
	AN3-10A	6	180	0
	D2931	2	677	0
	D4021-5	2	24	0
150-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W3	2	448	0
	MS21042L3	6	1,476	0
	NAS1149F0332P	12	2,802	0
	NAS1149FN832P	2	2,457	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		MRB (QS1042)	
Date: _____ Sequence #: _____		QTY Affected: _____		Disposition			
Description Work Order Deviation		Completed By					
Lead hand / Supervisor		QC / QA Coordinator					

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY									
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details:		Other/Details:									

9/25/2019

[Dart Hawkesbury] Labor Records - Laviolette, Carl



Dart Aerospace Ltd.
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Labor Records

Period: Current Month	Dates: 9/24/2019 - 9/25/2019	Sort by: Date/Time Ascending
Workcenter: *	Workcenter Type: *	Part: D4034-043
Employee: Laviolette, Carl	Job No: *	Operation: *
Cost Sub Type: *	Department: *	Warehouse: *
Shift: *	Include: * All* Contract Only* Non Contract Only*	
Include Summary: No		

Type	Workcenter	Part	Job	Operation	Date	Begin	End	Hours	Name	Shift
Labor (Production)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	8:53 AM	8:55 AM	.03	Laviolette, Carl	24Hr Shift
Indirect Labor (Team Meeting)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	8:55 AM	9:52 AM	.95	Laviolette, Carl	24Hr Shift
Indirect Labor (Lead Hand Activity)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	11:56 AM	12:00 PM	.07	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	12:35 PM	1:03 PM	.47	Laviolette, Carl	24Hr Shift
Indirect Labor (Team Meeting)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	1:03 PM	1:09 PM	.10	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/24/19	1:08 PM	4:31 PM	3.38	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D4034-043	199771	Large Fab - Basket - 1	9/25/19	8:08 AM	10:49 AM	2.68	Laviolette, Carl	24Hr Shift
Total 7 Records								7.68		

CANCEL
TIME ON

D 3913-041

JOB# 199697

ADD
TIME
TO

Scanned on wrong
JOB



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Labor Records

Period: Current Month	Dates: 9/1/2019 - 9/25/2019	Sort by: Date/Time Ascending
Workcenter: *	Workcenter Type: *	Part: *
Employee: *	Job No: 199697	Operation: *
Cost Sub Type: *	Department: *	Warehouse: *
Shift: *	Include: * All* Contract Only* Non Contract Only*	
Include Summary: No		

Type	Workcenter	Part	Job	Operation	Date	Begin	End	Hours	Name	Shift
Labor (Production)	Large Fab - 9	D3913-041	199697	Large Fab - Basket - 1	9/17/19	10:22 AM	10:55 AM	.55	Young, Jessey	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/20/19	10:35 AM	11:58 AM	1.38	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/20/19	12:40 PM	3:46 PM	3.10	Laviolette, Carl	24Hr Shift
Indirect Labor (Lead Hand Activity)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	8:18 AM	9:58 AM	1.67	Laviolette, Carl	24Hr Shift
Indirect Labor (Team Meeting)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	9:58 AM	10:16 AM	.30	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	10:15 AM	11:56 AM	1.68	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	12:39 PM	2:25 PM	1.77	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	2:32 PM	2:39 PM	.12	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	3:20 PM	3:47 PM	.45	Laviolette, Carl	24Hr Shift
Indirect Labor (Lead Hand Activity)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/23/19	4:03 PM	4:10 PM	.12	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/24/19	8:18 AM	8:48 AM	.50	Laviolette, Carl	24Hr Shift
Indirect Labor (Lead Hand Activity)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/24/19	8:48 AM	8:53 AM	.08	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/25/19	10:50 AM	10:52 AM	.03	Laviolette, Carl	24Hr Shift
Indirect Labor (Lead Hand Activity)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/25/19	10:51 AM	11:16 AM	.42	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/25/19	11:15 AM	11:58 AM	.72	Laviolette, Carl	24Hr Shift
Labor (Production)	Large Fab - 4	D3913-041	199697	Large Fab - Basket - 1	9/25/19	12:37 PM	12:49 PM	.20	Laviolette, Carl	24Hr Shift
Total 16 Records								13.08		